

# Work Order ID 87009

Monday, July 09, 2012 3:47:38 PM

**\*87009\***

Page 1

Item ID: D4021-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Handle Plate

Stop **\*NS2\***

Start Date: 7/10/2012 Start Qty: 9.00

**\*9\***

Cust Item ID:

Required Date: 7/13/2012 Req'd Qty: 9.00

**\*9\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/07/10 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code Accept  
Qty Reject  
Qty Reject  
Number Insp.  
Stamp

Draw Nbr

Revision Nbr

D4021

B

100

0.00

**\*100\***

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D4021

Prog Rev: B

Dwg Rev: B

304 . 125

Deburr as required

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Memo

0.00

Quality Control

10 0 Jm 12-7-12

10 0 Jm 12-7-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 87009

\*87009\*

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Monday, July 09, 2012 3:47:38 PM

Item ID: D4021-1

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Handle Plate

Stop \*NS2\*

Start Date: 7/10/2012 Start Qty: 9.00

\*9\*

Cust Item ID:

Required Date: 7/13/2012 Req'd Qty: 9.00

\*9\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Memo

0.00

Quality Control

DAS  
16  
9-89 12/07/16

110

140

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00

\*140\*

Packaging

Memo

0.00

Packaging

10x 12.07.18

150

QC21- Final Inspection - Work Order Release

0.00

\*150\*

QC

Memo

0.00

Quality Control

12/7/19

mf 12.07-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, July 09, 2012 3:47:38 PM

Page 1

Work Order ID: 87009  
 Parent Item: D4021-1  
 Parent Item Name: Handle Plate

Start Date: 7/10/2012 Required Date: 7/13/2012  
 Start Qty: 9.00 Required Qty: 9.00

Comments: IPP RevA: new issue DD 09.11.25 verified by:EC IPP Rev:B as per dwg REV.A DD  
 10.02.22 verified by:EC IPP Rev:C as per dwg revB DD 10.04.20 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 304/316 0.125 Sheet		Purchased	No			100	sf	45.0260	0.1225	1.1605263			

Location

Loc Qty

Loc Code

MAT020

45.026

121380

23.9

121780

21.126

121780

Sm 12-7-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

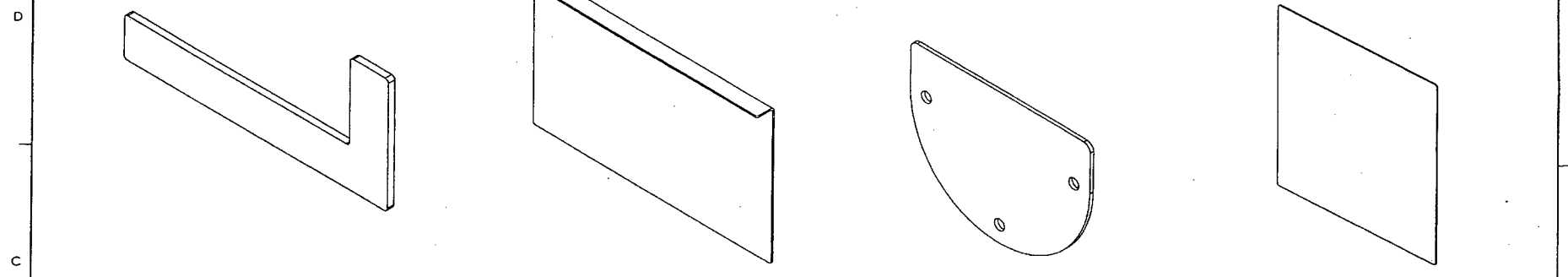
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

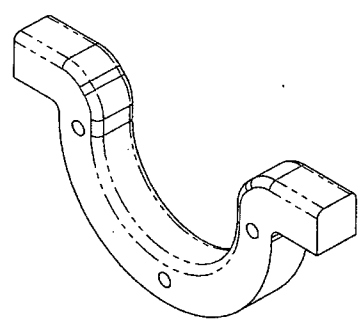


**D4021-1 HANDLE PLATE**

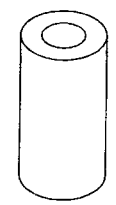
**D4021-3 DATA PLATE**

**D4021-5 BLANKING PLATE**

**D4021-11 INSTRUCTIONS PLATE**



**D4021-7 HOOP**

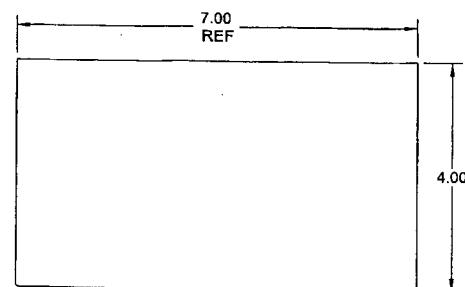


**D4021-9 BUSHING**

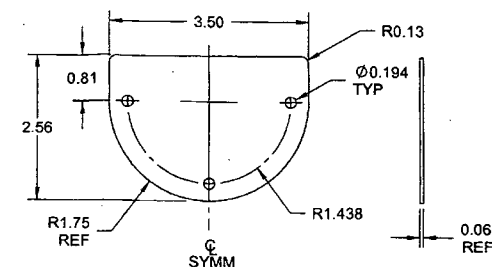
**RELEASED**  
2010-04-14  
WJP

B	POWDER COAT SPEC ADDED TO NOTE 2 (A8-2)	JPH	10.04.06
A	NEW ISSUE	JPH	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. B
MFG. APPR.	JPH	D4021	SHEET 1 OF 3
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	MISC PARTS - 350 BASKET	NTS
DATE	10.04.06	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

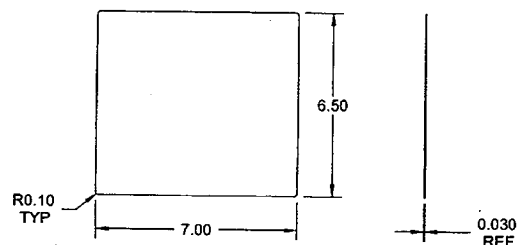
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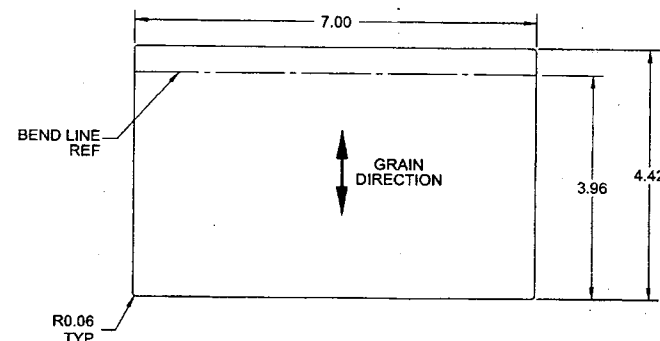
**D4021-3 DATA PLATE**  
MAKE FROM D4021-3F



**D4021-5 BLANKING PLATE**



**D4021-11 INSTRUCTIONS PLATE**



**D4021-3F DATA PLATE**  
**FLAT PATTERN**

RELEASED  
2010-04-14  
NMP

- 1) MATERIAL -1: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S11GA

- 3F: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S20GA

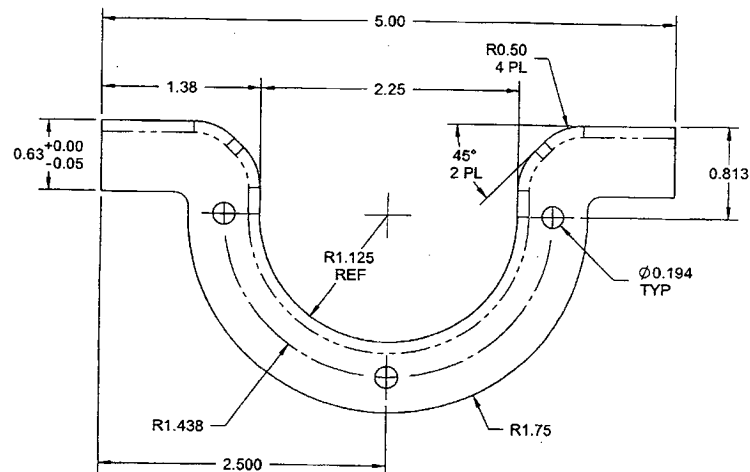
- 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M303S16GA OR M304S16GA

- 11: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S22GA

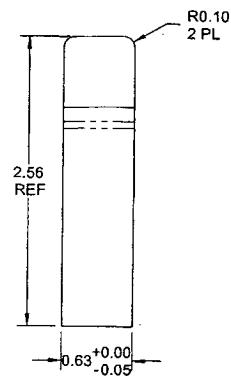
- A) FINISH: -1/3-11: NONE  
          -5: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
3) TOLERANCES: PART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT -1: 0.18 lbs                 -3: 0.35 lbs  
            -5: 0.14 lbs                 -11: 0.39 lbs

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D4021</b>  TITLE <b>MISC PARTS - 350 BASKET</b>  COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS TO BE USED ONLY FOR THE EXPRESS PURPOSE THAT IT IS NOT TO BE LOANED TO ANY PERSON OR COPIED OR REPRODUCED IN ANY OTHER FORM WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	REV. B
DRAWN	JPH		SHEET 2 OF 3
CHECKED			SCALE
MFG. APPR.			NTS
APPROVED			
DE APPR.			
DATE	10.04.06		

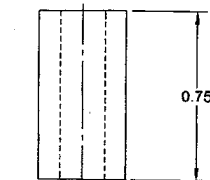




**D4021-7 HOOP**






**D4021-9 BUSHING**



**NOTES:**

- 1) MATERIAL-7: 304/316 STAINLESS STEEL BAR, PER ASTM A276  
REF DART SPEC M304B
- 9: 304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276  
REF DART SPEC M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -7: 0.80 lbs  
-9: 0.02 lbs

**RELEASED**  
2010-04-14  
NR

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO.	REV. B
MFG. APPR.		<b>D4021</b>	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>MISC PARTS - 350 BASKET</b>	NTS
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